

Date: Tuesday, 3/18/2008 3:55:21 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, RH
Job Number	: 38089		
Estimate Number	: 10947		
P.O. Number	:	Part Number	: D2480012
This Issue	: 3/18/2008 S.O. No. :	Drawing Number	: D2480 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LARGE FAB ASSY	Drawing Revision	: A1
Previous Run	: 37460	Material	:
Written By	:	Due Date	: 3/28/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>08 03 18</u>		
Comment	: Est. C1 03.01.09 Added Powder Coat		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2478	Lower Arm
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B37462 → 3x

2.0	D2479	Upper Arm
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B37463 → 3x

3.0	D2481	Lower Mount Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	23503 → 6x

4.0	D2482	Upper Mount Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B14648 → 3x

08/03/19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, RH

Job Number: 38089

Part Number: D2480012

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

LD 08/03/20 (3)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-20 (3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LD 08/03/20 (3)

8.0

POWDER COATING

POWDER COATING



M107005



(3X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m.f 08/03/24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(3)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-03-24

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPA 37450 / 8/3/25 (3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

LD 08/03/26

Job Completion



LD 08-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

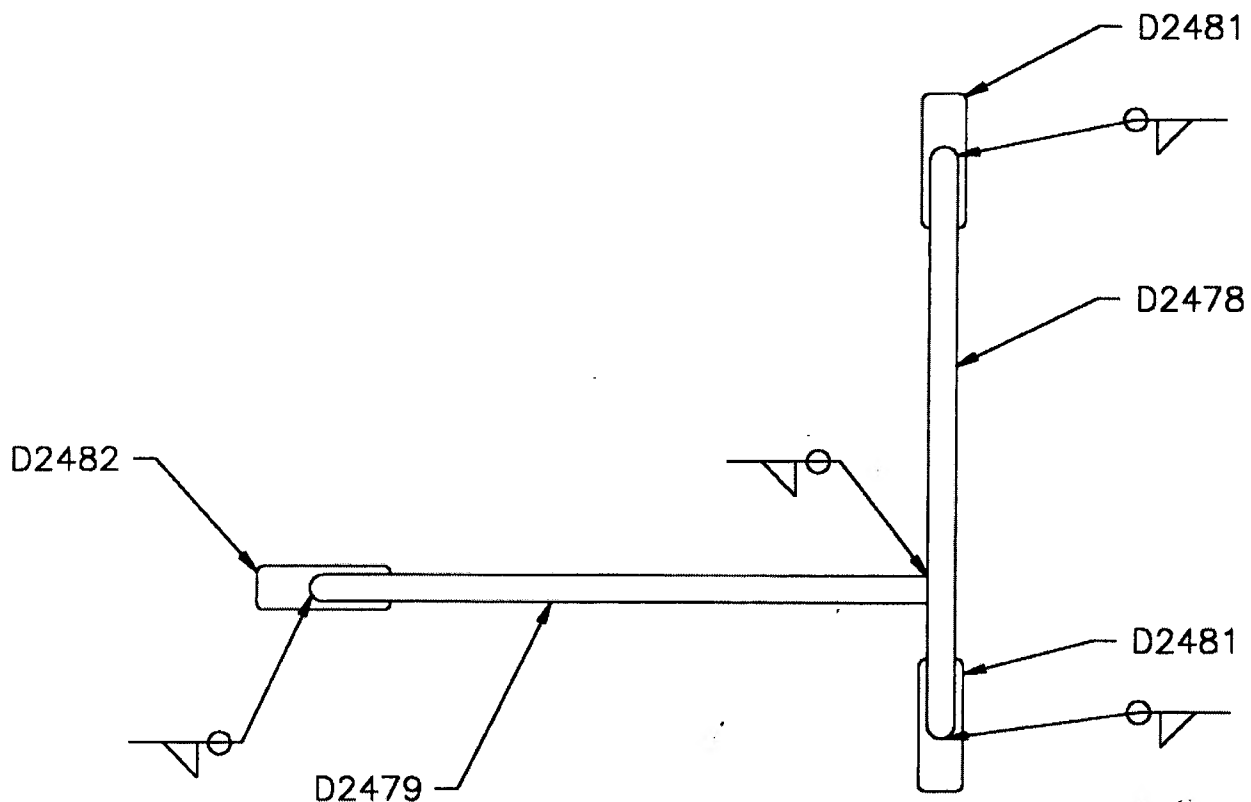
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1	05.06.23	ADDED POWDER COAT	

RELEASED  
96/06/02 DS



D2480-011 LH SHOWN  
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004  
A1 2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38089